



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4775-041

Job Sheet 173364



Part No: D4775-041

Job Qty: 2 ea

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/1/18

Job Tracking No:

Due Date: 3/2/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.08.26 PB1 DD
VERF:JLM IPP REV:C 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:D 14.01.10 AS PER REV.C DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	3/1/18	3/1/18	0.00	0.00	Start Up Stores/Pkg-1		CB
110	Packaging	2 pcs	3/1/18	3/1/18	0.00	0.00	Packaging1-5		SB
120	Small Fab	2 pcs	3/2/18	3/2/18	0.00	0.83	Small Fab-7		SB
130	QC	2 pcs	3/2/18	3/2/18	0.00	0.00	QC5		38
140	Packaging	2 pcs	3/2/18	3/2/18	0.00	0.00	Packaging3-2	5+357	6 MAR 06 2018
150	QC21-SA	2 Ea	3/2/18	3/2/18	0.00	0.00	QC21		38

Part Op 120 - 1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG A/R PROSEAL
Descriptions: BATCH: 138708 2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

DAS MAR 07 2018
21
9-80

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-10A	349 Bolt	4 Ea (2 ea)	90-Start up Operation	5041477
D4775-1	357 Strut Tube	2 Ea (1 ea)	90-Start up Operation	5041887
D4776-1	124 Basket Strut Clevis	2 Ea (1 ea)	90-Start up Operation	5016124
D4776-5	115 Spacer	8 Ea (4 ea)	90-Start up Operation	5014805
D4777-1	116 Rod End Bearing	2 Ea (1 ea)	90-Start up Operation	5018674
MS21042L3	303 Nut	4 Ea (2 ea)	90-Start up Operation	5037184-1
MS21209-F615	Heli-Coil	2 Ea (1 ea)	90-Start up Operation	5042060

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-10A	4	324	0
	D4775-1	2	2	0
	D4776-1	2	20	0
	D4776-5	8	5	0
	D4777-1	2	6	0
	MS21042L3	4	3,357	0
	MS21209-F615	2	112	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : _____					

Part Specifications

Specifications could not be found.

Plex 3/1/18 7:26 AM dart.lace 



Container No: S047728



Part: D4775-041

Job No: 173364

Serial No/Batch: S047728

Revision:

Inspector:

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/05/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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